

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24210
<b>Description:</b> Wearplate	<b>Part Number:</b>	D3319-3
Dwg: D3319 Rev. <u>B</u> page 2 <u>per PH 05-09-02</u>	<b>Qty:</b>	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05-09-02	4
2	PG	Issue P/O: <u>7008582</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser <b>Material release note is required</b>	U	05-09-02	4
3	RG	Receive and inspect for transit damage <b>Ensure material release note is attached</b>	CL	05/09/20	4
4	QC6	Inspect dimensions as per inspection template D3319-3T1	U	05-09-20	4
5	GA	Deburr if necessary	N/A		
6	GB	Form using DT8326 & DT8261 as per Dwg D3319 Dwg Rev: <u>B</u>	SB	05/09/20	4
7	QC6	Inspect dimensions as per Dwg D3319	2	05-09-21	4
8	WS	Weld hard surface using D3319-3T2 as per QSI 004 and Dwg D3319-3-T3 layout Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod <u>617914</u> Dwg Rev: <u>B</u>	CL	05-09-21	2
9	QC9	Inspect weld	U	05/09/26	2
10	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	MI	05-09-27	2
11	QC3	Inspect Powder Coat	CL	05/09/27	2
12	ST	Identify on inside surface using a permanent fine point marker with the following: <b>TCCA-PDA, Dart Aerospace Ltd.</b> <b>P/N: D3319-3, B/N: BXXXXX</b> <b>For Product Eligibility see PDA04-48 PDA05-18 and Stock</b>	SB	05/09/27	2
13	AC	Cost / part: <u>81.02</u>	CL	05/09/27	2
14	DC	Close W/O Inspect Level 21	545	05-09-27	2

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM-	

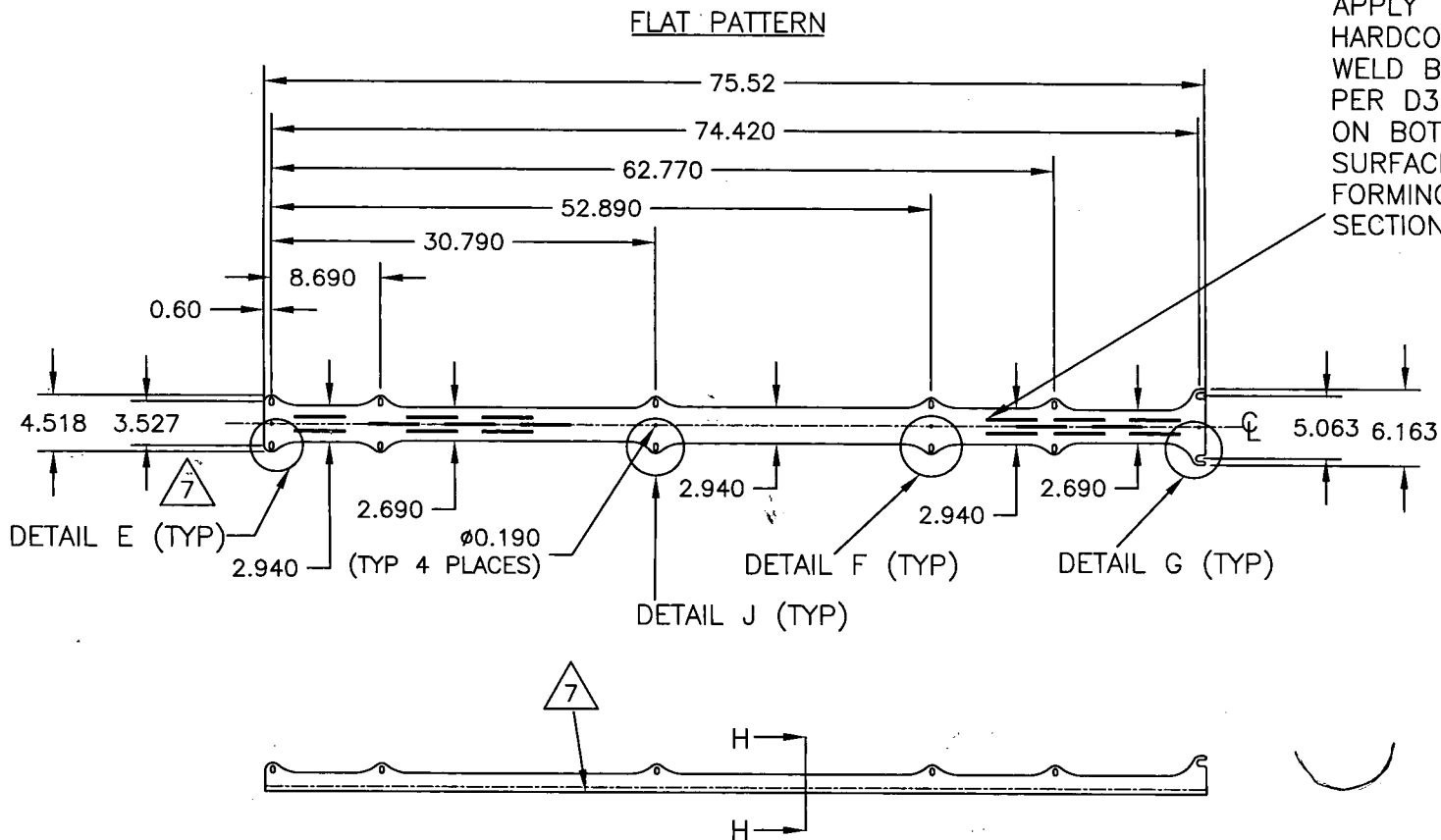
**PRELIMINARY ISSUE**

Step 8. Permanent change as shown. JWS/05-09-21

Step 8. remove 1 for welding jig

U 05-09-21

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APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H

### BENDING DETAIL

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA04-XX"

NO. 24210

11	2PY
7	ENT
PHC	

ST COPY

DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
		D3319		SHEET 2 OF 5	
DATE		TITLE		SCALE	
05.06.06		WEARPLATE		1:15	

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 02, 2005  
01:45 pm

Work Order No : 0024210  
Project Name : D3319-3  
Project For : WK537  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3319-3  
Description : Wearplate  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 09-02-05  
Est Finish Date : 09-12-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

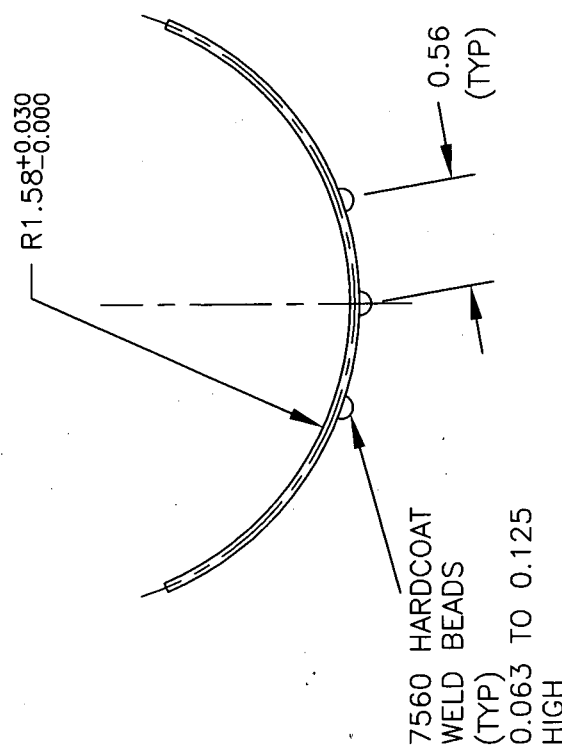
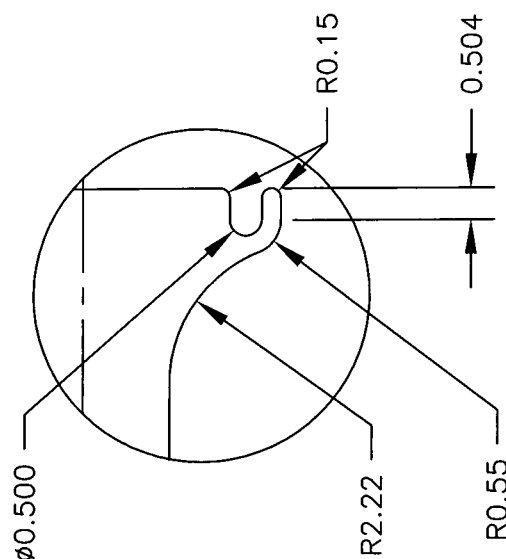
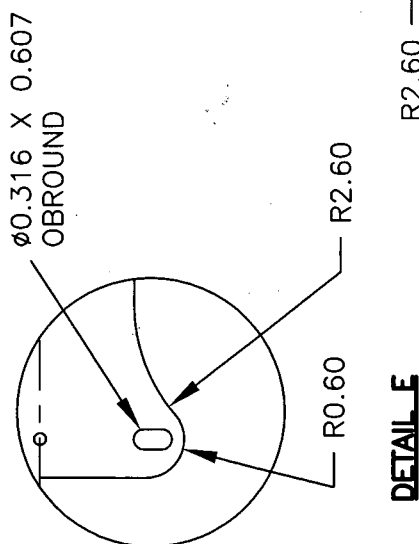
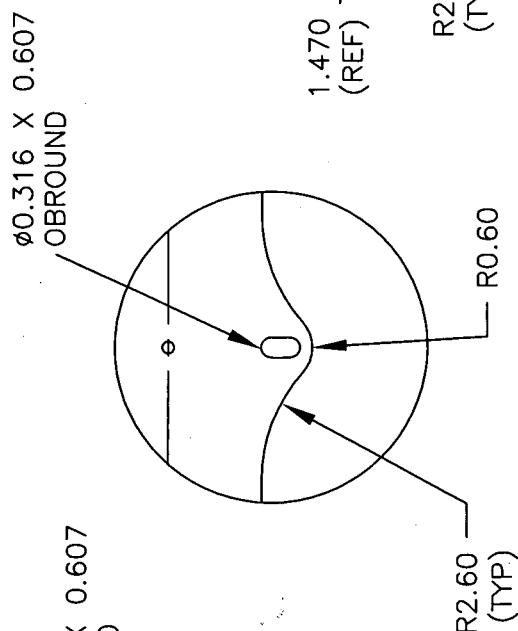
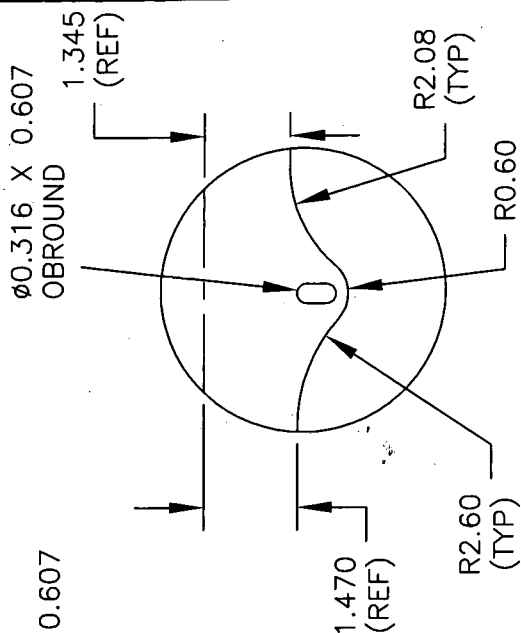
Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

**PRELIMINARY ISSUE**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3319	REV. A SHEET 5 OF 5
DATE 04.09.24	TITLE WEARPLATE		SCALE 1:3



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New Zealand Steel Limited  
Glenbrook, South Auckland  
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Telephones: (09) 375 8989 / 375 8111 Auckland  
(09) 235 8089 / 235 3535 Waiuku  
Fax: (09) 375 8959

# TEST CERTIFICATE

Ref: 5005/21329

STEEL

Fax: (09) 375 8899

CUSTOMER		Wilkinson	P41007DI002		SPECIFICATION		ASTMA1008 CS Type A		CERTIFICATE No		TC107797	
CUSTOMER O/N		90-21N-288			PRODUCT		CRA WIDE COIL		PAGE		1 of 1	
MILL O/N		453666			DIMENSIONS		0.044" x 48" x Coil		DATE		31 March 2005	

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)								
		C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000											x10000	x100	180°				G.L. =	HRB	( )
R9-455948-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1729
R9-455949-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1296
R9-455951-00	638405	5	1	20	13	19	12	19	17	1	5	1	1					Good				49		2064
R9-456216-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1926
R9-456217-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1978
R9-456218-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1926
R9-456219-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1978

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	(A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 ± So (F)=8"	(A)=0 (C)=45 (B)=90 (D)=(r0+r90+2r45)/4	(C)=5mm x 5mm (A)=10mm x 10mm (B)=7.5mm x 10mm	(A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra  
QC METALLURGIST

18 ya CRMS

## Peter Hum

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**From:** David Shepherd [davids@dartaero.com]  
**Sent:** Tuesday, September 27, 2005 10:50 AM  
**To:** Peter Hum  
**Subject:** Re: D3319-1/-3 changes

Peter,

It is acceptable to ship these parts. I will sign off the updated drawings when I am in Hawkesbury later this week.  
Please ensure W/O refers to Rev. B of the drawings.

David

----- Original Message -----

**From:** "Peter Hum" <phum@dartaero.com>  
**To:** "David Shepherd (E-mail)" <davids@dartaero.com>  
**Sent:** Tuesday, September 27, 2005 8:39 AM  
**Subject:** D3319-1/-3 changes

> David,  
>  
> The D3319-1/-3 wearplates for use on the D350-727-015 kit have been  
modified  
> to Rev. B. Rev. B has not been released. A fit and function has been  
> performed and photographed to show that the D3319-1/-3 Rev. B wearplates  
fit  
> an OEM 350 skidtube. Is it suitable to ship the D3319-1/-3 wearplates at  
> Rev. B?  
>  
>  
> Peter  
>  
>